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D5423-1

Job Sheet 183982



Part No: D5423-1

Job Qty: 6 ea

Part Name: Bearpaw



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/1/18

Job Tracking No:

Due Date: 10/12/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV A IPP REV:A NEW ISSUE JLM VERIFIED BY:DD

Ship Via:

## Bill of Materials

## Job Routing

| Op No | Operation              | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off    |
|-------|------------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|-------------|
|       |                        |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |             |
| 120   | Waterjet               | 6 pcs | 10/12/18   | 10/12/18 | 0.00      | 7.89    | Waterjet 1            | DAS       | OK 18/10/02 |
| 130   | CNC Vertical Machining | 6 pcs | 10/12/18   | 10/12/18 | 0.96      | 33.33   | HAAS1-1               | 52        | 18/10/18    |
| 140   | QC                     | 6 pcs | 10/12/18   | 10/12/18 | 0.00      | 0.00    | QC2 Machining-4       | 9-89      | 18/10/17    |
| 150   | QC                     | 6 pcs | 10/12/18   | 10/12/18 | 0.00      | 0.00    | QC8 Machining-4       | 9-89      |             |
| 160   | Packaging              | 6 pcs | 10/12/18   | 10/12/18 | 0.00      | 0.00    | Packaging3            | DAS       | NOV 06 2018 |
| 170   | QC21-SA                | 6 Ea  | 10/12/18   | 10/12/18 | 0.00      | 0.00    | QC21                  | 21        | NOV 06 2018 |

Part Op 120 - Cut Blank as per D5423-1 blank file

Descriptions: 130 - 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FB481 and Dwg D5423

## Job BOM

| Part / Item | Component Name    | Quantity     | Operation    | Container |
|-------------|-------------------|--------------|--------------|-----------|
| MUHMWB1.250 | UHMWB 1.250 BLACK | 42 sf (7 ea) | 120-Waterjet |           |

## Job Allocations

| Operation    | Component Part | Required | Inventory | Allocated |
|--------------|----------------|----------|-----------|-----------|
| 120-Waterjet | MUHMWB1.250    | 42       | 29        | 0         |

## Part Specifications

Specifications could not be found.

Plex 10/1/18 10:22 AM Dart.Gagnon.Michelle

**DART**  
AEROSPACE

Container No: **S115403**



Part: **D5423-1**

Job No: **183982**

Serial No/Batch: **S115403**

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 10/02/18



|                              |               |                     |         |
|------------------------------|---------------|---------------------|---------|
| <b>DART AEROSPACE LTD</b>    |               | <b>Work Order:</b>  | 183982  |
| <b>Description:</b> Bear paw |               | <b>Part Number:</b> | D5423-1 |
| <b>Inspection Dwg:</b> D5423 | <b>Rev:</b> A | <b>Page 1 of 1</b>  |         |

### INSPECTION SHEET

| Drawing Dimension | Tolerance       | Actual Dimension | Accept | Reject | Method of Inspection | Comments  |
|-------------------|-----------------|------------------|--------|--------|----------------------|-----------|
| 6.70              | ± .030          | 6.695            | ✓      |        | Vern                 |           |
| 4.25              | ± .030          | 4.232            | ✓      |        | "                    |           |
| 1.63              | ± .030          | 1.626            | ✓      |        | "                    |           |
| 0.38              | ± .030          | 0.378            | ✓      |        | "                    |           |
| 4.13              | REF.            | 4.125            | ✓      |        | "                    |           |
| 0.38              | ± .030          | 0.378            | ✓      |        | "                    |           |
| Ø0.261            | + .005 / - .001 | 0.260            | ✓      |        | "                    |           |
| 1.00              | ± .030          | 1.002            | ✓      |        | "                    |           |
| 0.25x45°          | ± .030          | 0.25x45°         | ✓      |        | "                    | chmr      |
| 19.00             | ± .030          | 19.00            | ✓      |        | Tape                 |           |
| 0.04x45°          | ± .030          | 0.04x45°         | ✓      |        | Vern.                | chmr      |
| 11.74             | ± .030          | 11.75            | ✓      |        | Vern.                |           |
| 6.62              | ± .030          | 6.615            | ✓      |        | Vern.                |           |
| 1.94              | ± .030          | 1.936            | ✓      |        | "                    |           |
| 44.50             | ± .030          | 44.500           | ✓      |        | Tape                 |           |
| 4.600             | ± .010          | 4.600            | ✓      |        | Vern                 |           |
| 4.51              | ± .030          | 4.505            | ✓      |        | "                    |           |
| 1.20              | ± .030          | 1.200            | ✓      |        | "                    |           |
| 0.95              | ± .030          | 0.953            | ✓      |        | "                    |           |
| 0.75              | ± .030          | 0.744            | ✓      |        | "                    |           |
| 0.25              | + .030 / - .010 | 0.244            | ✓      |        | "                    |           |
| 0.37              | + .030 / - .010 | 0.372            | ✓      |        | "                    |           |
| Ø.93              | ± .030          | 0.930            | ✓      |        | "                    | C. Bore Ø |
| 0.30              | ± .030          | 0.310            | ✓      |        | D.G.                 | C. Bore ↕ |
| 0.06x45°          | ± .030          | 0.06x45°         | ✓      |        | Vern                 | chmr      |
| R0.25             | ± .030          | 0.250            | ✓      |        | R.G.                 |           |
|                   |                 |                  |        |        |                      |           |
|                   |                 |                  |        |        |                      |           |
|                   |                 |                  |        |        |                      |           |

|                            |                    |                      |
|----------------------------|--------------------|----------------------|
| <b>Measured by:</b> DFP/DA | <b>Checked by:</b> | <b>QC Inspector:</b> |
| <b>Date:</b> 18-10-17      | <b>Date:</b>       | <b>Date:</b>         |

|                                                |              |
|------------------------------------------------|--------------|
| <b>Engineering Approval:</b><br>(If necessary) | <b>Date:</b> |
|------------------------------------------------|--------------|

| Rev | Date     | Change    | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A   | 14.07.31 | New Issue | KJ         |          |

